

Date: Monday, 1/8/2007 7:57:36 AM
User: Jean-Luc Menard

Process Sheet

split
07/01/15

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 30204	
Estimate Number : 12631	
P.O. Number : <i>N/A</i>	Part Number : D2127251905
This Issue : 1/8/2007 S.O. No. : <i>N/A</i>	Drawing Number : D212-725-1 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i> 07-01-09	Due Date : 1/15/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 3 Um: Each
Comment : Est Rev:A New Issue 07-01-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W
		<i>50"</i>
Comment: Qty.: 3.1500 f(s)/Unit Total : 9.4500 f(s)		
304 RD Seamless Tube 1.0" x .049W		
Batch: <i>M19448</i>		<i>FF 07-01-10</i>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Form as per Dwg D212-725-1 & Template DT8907		<i>FF 07-01-10</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>207-01-15 (3)</i>
4.0	MS2081916J	Sleeve
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)		
Sleeve		
Batch: <i>M17123 (α 5)</i>		<i>(1)</i>
5.0	AN81816J	Nut
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)		
Nut		
Batch: <i>M103177 (α 2) / M1256 (α 1)</i>		<i>(1)</i>

Process Sheet

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Drawing Name: TUBE ASSEMBLY

Job Number: 30204

Part Number: D2127251905

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Flare and Install Sleeves & Nut as per Dwg D212-725-1.

FF 07-01-15

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/01/15 ①

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

U 07-01-15

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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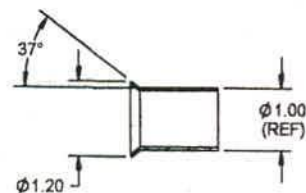
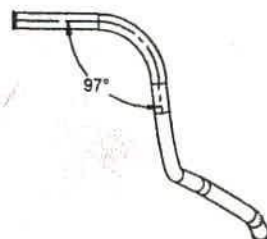
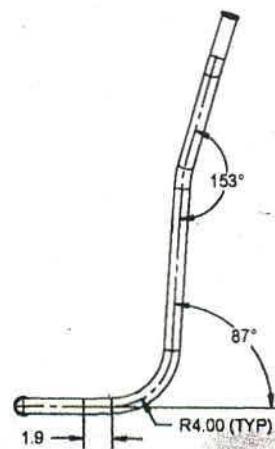
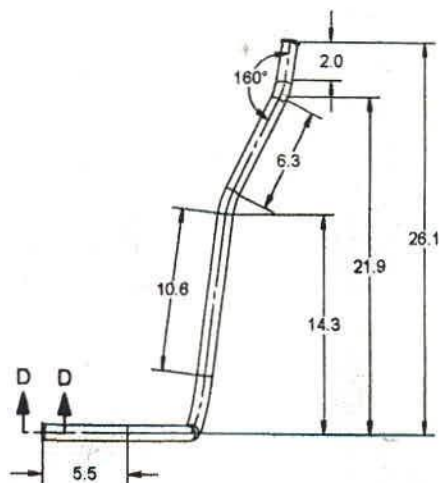
Comment: FINAL INSPECTION/W/O RELEASE

07/01/15 ①

Job Completion



U 07-01-15

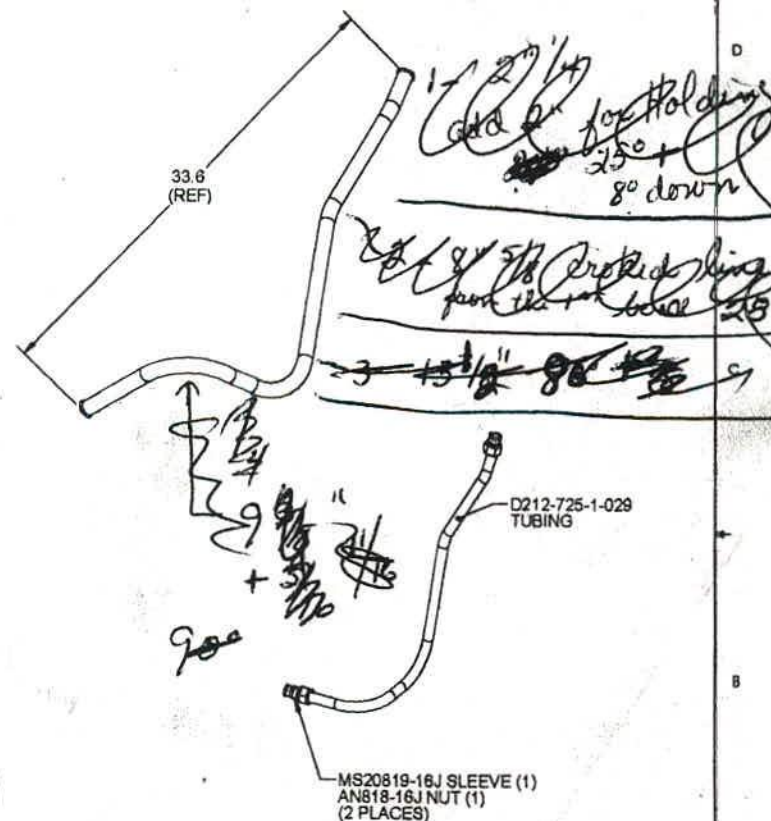


D212-725-1-029 TUBING
MANUFACTURE PER TEMPLATE DT8907

SECTION D-D
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 1:2
(2 PLACES)

NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL 1.00 O.D. x 0.049 WALL
(REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY ASSEMBLY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-905 TUBE ASSEMBLY

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 10 OF 37
DATE 06.12.08	TITLE 212S DETAIL PARTS		
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